



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBEA62309
Job Sheet 193145



Part No: RBEA62309

Job Qty: 1 pcs

Part Name: AS350/355 Field Maintenance



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEA62309 rev.T IPP REV:A 17.12.13 NEW ISSUE DD VERF:DP/IPP Rev.B 19.02.28 drawing revision
DP Verify DD/IPP Rev. C 19.04.01 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - Issue SN	1 pcs	5/6/19		0.00	0.00	Small Fab - 1		MLC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
105	Small Fab - 2 - B4B	1 pcs	5/6/19		0.00	1.00	Small Fab - 1 - B4B		MLC
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 5	1 pcs	5/6/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		

Plex 4/9/19 10:18 AM Dart.lajeunesse.marie



Container No: S195439



Part: RBEA62309

Job No: 193145

Serial No/Batch: S195439

Revision: T

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/03/19

				QC 5 - 40		JUL 04 2019	40 9-89
130	Packaging 3-1 - Stock - B4B	1 pcs	5/6/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	DAS
						Packaging 3 - 6 - B4B	28
						Packaging 3 - 7 - B4B	9-89
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	5/6/19	0.00	0.00	QC 21 - FG - 21	DAS
						QC 21 - FG - 70	21
						QC 21 - SA - 53	9-89

Part Op 100 - Issue S/N.

Descriptions: 105 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1750-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per drawing.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location:_____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1750-E	Pelican Case 1750	1 Ea (1 ea)	100-Small Fab - Issue SN	5180612
5274T761	Polypropylene Vial for Flange Wrench Bolts	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5142197
7189K31	Cable Ties Black	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5038430
9052000	10" Mini Bungee Cord	4 Ea (4 ea)	105-Small Fab - 2 - B4B	5094607
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	105-Small Fab - 2 - B4B	5163934
NAS1756-12	Remove Before Flight	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5183173
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5021040
RBE-350DAMPER	Damper Spanner Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5186939
RBE-350HYD	Hydraulic Accumulator Fitting Gauge	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5115954
RBE-350INCLINOMETER	Inclinometer	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5184009
RBE-350TDRS	Tail Rotor Driveshaft Bearing Run-Out Gauge	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5129866
RBE-350TEMP	Temperature Probe	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5186244
RBE350A93-3200-20-1	Main Gear Box/Rotor Brake Retaining Nut Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5115432
RBE350A93-3205-00E	Engine Gear Box Input Flange Holding Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5184802
RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5168994
RBE350A93-3300-20	Tail Rotor Hub Socket	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5167961
RBE350A93-3302-02	Tail Rotor Hub Lock Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5186226
RBE350A93-3303-02	Tail Rotor Head Body Extractor Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5191505
RBE350A93-3305-20-1	Tail Gearbox Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5120027
RBE350A93-3307-00	Tail Gearbox Seal Extractor	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5188513
RBE350A93-3312-03	Tail Rotor Hub Bushing Replacement Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5186550
RBE350A93-3316-20-1	Rotating Star Replacement Wrench	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5168539
RBE350A93-3317-20	Tail Rotor Hub Insert Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5172722
RBE350A93-3400-00	Drive Shaft Thimble	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5115898
RBE350A93-3500-00	Bearing Extractor	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5186607
RBE350A93-3501-20	Extraction Tool, Hydraulic Pump Pulley Bearing	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5122684
RBE350A94-2704-00	Pedals Locking Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5186633
RBE350A94-2706-00	Rigging Pin Set	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5186659
RBE350A94-2708-01	Tail Rotor Blade Locking Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5191362
RBE350A94-3301-00	Tail Rotor Accelerator Support	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5188042
RBE350A94-3700-A	Swashplate Immobilizing Tools Long Brace & Parts	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5187059
RBE350A94-3700-B	Swashplate Immobilizing Tool, Short Brace Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5187856
RBE350A94-3700-C	Swashplate Immobilizing Tools Adjustable Brace	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5183103
RBE350A94-3701-00	7° Main Rotor Rigging Tool	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5155061
RBE350A94-5201-20	Cartridge, Dummy, Fuel	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5178016
RBE703A94-1130-01	Main Rotor Blade Trim Tab Tools Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	
RBE703A95-0505-00-15	TGB Drain Tube Quill Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5181666
RBE703A95-0508-00-15	MGB Drain Tube Quill Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5191040
RBE703A95-0508-00-17	MGB Drain Tube Hose Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5194282
RBE703A95-0520-01-17	Engine & Hydraulic Drain Tube Quill Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5192352
RBE703A95-0520-01-19	Engine & Hydraulic Drain Tube Hose Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5194091
RBEA62309-2	Bottom Cushion use in case APP-1750-E	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5180609
RBEA62309-3	Stiffener Assembly	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5194576
RBEA62309-6	Top Cushion use in case APP-1750-E	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5180610
RBEA62309-7	Top Foam Cushion use in case APP-1750-E	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5180611
RBEA62309-8	Top Shelf Placard	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5191857
RBEA62309-9	Bottom Shelf Placard	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5179694
RBEA62310	AS350/355 Engine Strut	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5194797
RBT18025-13	Linear Scale (50 lbs)	1 Ea (1 ea)	105-Small Fab - 2 - B4B	5193257
RBW109-3101-58-1-1	Hammer, Steel	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5183172
RBW109-3101-58-2-1	Hammer, Aluminum	1 pcs (1 ea)	105-Small Fab - 2 - B4B	5183163

RBE703A94-1130-01-01

-23

5187052

5178120

016732

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - Issue SN	APP-1750-E	1	10	0
105-Small Fab - 2 - B4B	5274T761	1	25	0
	7189K31	1	761	0
	9052000	4	75	0
	97524A032	4	349	0
	NAS1756-12	1	235	0
	RB41011	1	352	0
	RBE-350DAMPER	1	5	0
	RBE-350HYD	1	14	0
	RBE-350INCLINOMETER	1	21	0
	RBE-350TDRS	1	21	0
	RBE-350TEMP	1	7	0
	RBE350A93-3200-20-1	1	17	0
	RBE350A93-3205-00E	1	11	0
	RBE350A93-3205-00T	1	12	0
	RBE350A93-3300-20	1	16	0
	RBE350A93-3302-02	1	2	0
	RBE350A93-3303-02	1	3	0
	RBE350A93-3305-20-1	1	11	0
	RBE350A93-3307-00	1	3	0
	RBE350A93-3312-03	1	7	0
	RBE350A93-3316-20-1	1	23	0
	RBE350A93-3317-20	1	7	0
	RBE350A93-3400-00	1	43	0
	RBE350A93-3500-00	1	7	0
	RBE350A93-3501-20	1	14	0
	RBE350A94-2704-00	1	8	0
	RBE350A94-2706-00	1	7	0
	RBE350A94-2708-01	1	5	0
	RBE350A94-3301-00	1	10	0
	RBE350A94-3700-A	1	7	0
	RBE350A94-3700-B	1	0	0
	RBE350A94-3700-C	1	5	0
	RBE350A94-3701-00	1	13	0
	RBE350A94-5201-20	1	8	0
	RBE703A94-1130-01	1	2	0
	RBE703A95-0505-00-15	1	5	0
	RBE703A95-0508-00-15	1	4	0
	RBE703A95-0508-00-17	1	4	0
	RBE703A95-0520-01-17	1	14	0
	RBE703A95-0520-01-19	1	10	0
	RBEA62309-2	1	12	0
	RBEA62309-3	1	6	0
	RBEA62309-6	1	12	0
	RBEA62309-7	1	12	0
	RBEA62309-8	1	22	0
	RBEA62309-9	1	7	0
	RBEA62310	1	3	0
	RBT18025-13	1	15	0
	RBW109-3101-58-1-1	1	10	0
	RBW109-3101-58-2-1	1	10	0

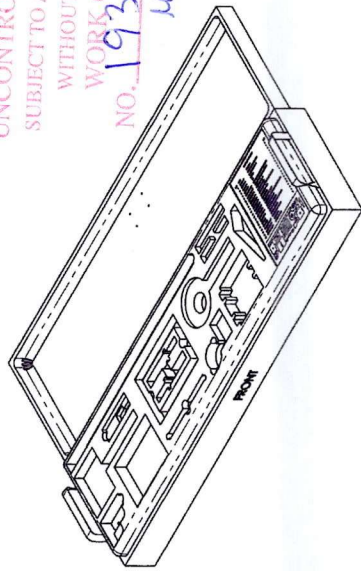
Part Specifications

Specifications could not be found.

Plex 4/9/19 10:18 AM Dart.lajeunesse.marie

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193145
15-04-09



RBEA62309 AS350/355 FIELD MAINTENANCE KIT

ITEM #	QTY	PART #	PART TITLE
-1	1	RBEA62309-1	PACKAGING ASSEMBLY
-8	1	RBEA62309-8	TOP SHELF PLACARD
-9	1	RBEA62309-9	BOTTOM SHELF PLACARD
-10	4	RBEA62309-10	HIGHLAND#9052000 OR EQUIV. (BUNGEE CORD 1/4" DIA. X 10' LG.)
-11	1	RBEA62309-11	NAS 1756-12 (REMOVE BEFORE FLIGHT FLAG)
-12	1	RBEA62309-12	McMaster#7180K31 OR EQUIV. (NYLON CABLE TIES 5-1/2" LG. X 1-1/8" MAX. BUNDLE DIA.)
-13	1	RBEA62309-13	McMaster#52741761 OR EQUIV. (PLASTIC VIAL 2" DIA. X 1-5/8" HT.)
14	1	RBE350A93-3200-20	MG/ROTOR BRAKE RETAINING NUT WRENCH
15	1	RBE350A93-3205-00E	ENGINE GIB INPUT FLANGE HOLDING WRENCH
16	1	RBE350A93-3205-00T	T/R GIB INPUT FLANGE HOLDING WRENCH
17	1	RBE350A93-3300-20	T/R HUB SOCKET
18	1	RBE350A93-3302-02	T/R HUB LOCK WRENCH
19	1	RBE350A93-3303-02	T/R BODY EXTRACTOR TOOL
20	1	RBE350A93-3305-20	TAIL GEARBOX WRENCH
21	1	RBE350A93-3307-00	TAIL GEARBOX SEAL EXTRACTOR
22	1	RBE350A93-3312-03	T/R HUB BUSHING REPLACEMENT TOOL
23	1	RBE350A93-3316-20	ROTATING STAR REPLACEMENT WRENCH
24	1	RBE350A93-3317-20	TAIL ROTOR HUB INSERT TOOL
25	1	RBE350A93-3400-00	DRIVE SHAFT THIMBLE
26	1	RBE350A93-3500-00	BEARING EXTRACTOR
27	1	RBE350A93-3501-20	EXTRACTION TOOL HYD. PUMP PULLEY BEARING
28	1	RBE350A94-2704-00	JAMMING TOOL, PEDALS
29	1	RBE350A94-2706-00	RIGGING PIN SET
30	1	RBE350A94-2708-01	T/R BLADE LOCK FIXTURE
31	1	RBE350A94-3301-00	T/R ACCELERATOR SUPPORT
32	1	RBE350A94-3700-A	SWASHPLATE IMMOBILIZING TOOL LONG BRACE
33	1	RBE350A94-3700-B	SWASHPLATE IMMOBILIZING TOOL SHORT BRACE
34	1	RBE350A94-3700-C	SWASHPLATE IMMOBILIZING TOOL ADJUSTABLE BRACE
35	1	RBE350A94-3701-00	M/R RIGGING TOOL
36	1	RBE350A94-5201-20	CARTRIDGE, DUMMIE, FUEL
37	1	RBE-350DAMP	DAMPER SPANNER WRENCH
38	1	RBE-350HYD	HYDRAULIC ACCUMULATOR FITTING GAUGE
39	1	RBE-350INCLINOMETER	INCLINOMETER
40	1	RBE-350TEMP	TEMPERATURE PROBE
41	1	RBE-350TRDS	T/R DRIVESHAFT BEARINGS RUN OUT GAUGE
42	1	RBE703A94-1130-01-01	IMMOBILIZING CLIP ASSEMBLY
43	1	RBE703A94-1130-01-23	DEFLECTION CLIP ASSEMBLY
44	1	RBE703A95-0505-00-15	TGB DRAIN TUBE QUILL ASSEMBLY
45	1	RBE703A95-0508-00-15	MG/ DRAIN TUBE QUILL ASSEMBLY
46	1	RBE703A95-0508-00-17	MG/ DRAIN TUBE HOSE ASSEMBLY
47	1	RBE703A95-0520-01-17	ENGINE & HYDRAULIC DRAIN TUBE QUILL ASSEMBLY
48	1	RBE703A95-0520-01-19	ENGINE & HYDRAULIC DRAIN TUBE HOSE ASSEMBLY
49	1	RBEA62310	AS350/355 ENGINE STRUT
50	1	RBT18025-13	LINEAR SCALE
51	1	RBW109-3101-58-1-1	HAMMER, STEEL
52	1	RBW109-3101-58-2-1	HAMMER, ALUMINUM
53	1	RB41011	DART PLACARD
54	4	McMaster#67524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. X 0.425" LG.

T	REPLACED ITEM -5 WITH DTSP10002 ITEM 58 WAS McMaster#97447A651 OR EQUIV. IS McMaster#9748A341 OR EQUIV. -2 DIM WAS 3.50 REF IS 3.29 -4 DIM WAS Ø 0.2610 257 THRU IS Ø 0.257 THRU -8 DIM WAS 1.63 REF IS 1.63 SEE PREVIOUS REVISIONS FOR MORE INFORMATION ITEM -10 WAS ITEM -9 ITEM -11 WAS ITEM -10 ITEM -12 WAS ITEM -11 ITEM -13 WAS ITEM -12 UPDATED BOM TO REFERENCE CORRECT TOOL NUMBERS TO BE INCLUDED IN KIT -8 ADDED HEAT CUT NOTE -8 ENGRAVING FOR BOTTOM SHELF REMOVED. UPDATED ENGRAVING -9 IS BOTTOM SHELF PLACARD. -10 P/N WAS McMaster#8835T83 (ELASTIC TIE DOWN) OR EQUIV. IS HIGHLAND#9052000 (ELASTIC TIE DOWN) OR EQUIV.	KPT 19-666
S		KPT 19-600
REV.	DESCRIPTION	ECN # BY
DESIGN	KPT	
DRAWN	KPT	
CHECKED	KPT	
MFG. APPR.	DP	
APPROVED	WJ	
DATE	3/27/2019	
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
REV. T SHEET 1 OF 11		
TOOL PART # RBEA62309		
TITLE AS350/355 FIELD MAINTENANCE KIT		
SCALE NTS		
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					